Work Order ID 50274

July 14, 2009 11:15:41 AM

Item ID: D350-591-312 **Accept** **Setup Start** **Stop**

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 7/27/09 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3272	Rev B								
100		0.00							
DC	DOCUMENT CONTROL								
Document Control	**Memo** 09/08/2009 for BG 01/06/09 Photocopy bluefile and type labels as per PPP D350-591-312 CHG001								
110		0.00							
Large Fab	Large Fab								
Large Fab	**Memo** 09-08-17 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod MIII494 3-Grind End Plate flush MIICi30	0.00				10			
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC									
Quality Control	**Memo** 09-08-18 ID	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 50274

July 14, 2009 11:15:41 AM

Item ID: D350-591-312 **Accept** **Setup Start**

Revision ID: B **Stop**

Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 7/27/09 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00	=> S 08/02/21			X10 RH	0		
	Memo	0.00							
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00	SAD 09-08-24			(10)			
	Memo	0.00							
150 QC Quality Control	QC3- Inspect Part Finish	0.00	09.08.24			10			
	Memo	0.00							

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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NOTE: Date & initial all entries

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Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 7/27/09 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Large Fab	0.00							
Large Fab									
Large Fab	**Memo**	0.00				10			
Large Fab	Assemble Leg Assembly as per Dwg D3272.					09.08.24			
170	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00				=> 8/02/13/25			
Quality Control						WORK			
180		0.00							
Large Fab	Large Fab								
Large Fab	**Memo**	0.00				09.08.25	10		
Large Fab	1-Bevel Aft end for welding☐2-Inspect for foreign object as per QSI 024☐3-Weld Aft End Plate as per QSI 004 & Dwg D3272☐A/RAluminum Rod MIL 311 ☐4-Grind End Plate flush ☐5-Install last rivet.								

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 50274

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Item ID: D350-591-312 **Accept** **Setup Start** **Stop**

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Start Qty:** 10.00 **Cust Item ID:**

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Run Start **Stop**

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	Memo	0.00							
200 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
210 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00							

PD 09.08.25

=> 09/08/25 (10 XRH) ϕ

=> 09/08/26 10 XRH ϕ

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 50274

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Start Date: 7/27/09 **Start Qty:** 10.00 **Cust Item ID:**

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo M112260	0.00							
Powder Coating	START TIME: 1:45pm OVEN TEMPERATURE: 320°F FINISH TIME: 2:15pm								
			⇒ 9/ 09/08/26			X10RH			6
230	Pressure Wash per QSI005 4.3	0.00	M 09/08/26			X10RH			6
HandFinish	WING WALK.								
Hand Finishing	Memo M112000	0.00	BR 09-08-27			10RH.			
240	QC3- Inspect Part Finish	0.00							
QC									
Quality Control	Memo	0.00				9/8/27			10x SP

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Work Order ID 50274

July 14, 2009 11:15:41 AM

Item ID: D350-591-312 **Accept** **Setup Start** **Stop**

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 7/27/09 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 Packaging Packaging	Pick Kit	0.00				9/8/27		10x	
	Memo	0.00							
260 QC Quality Control	QC4- 100% Inspect kits for completeness	0.00 => 8 02/08/08				+10 RH	0		
	Memo	0.00							
270 Packaging Packaging	Packaging	0.00				9/8/1 59		10x	
	Memo	0.00							
	Identify and pack for shipping as per PPP D350-591-312 Location: _____ Rev D								

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 50274

July 14, 2009 11:15:41 AM

Item ID: D350-591-312
Revision ID: B
Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Start Qty:** 10.00
Required Date: 7/27/09 **Req'd Qty:** 10.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00				09/09/01			
QC	**Memo**	0.00							
Quality Control									

MF 09-09-01

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 11:15:39 AM

Work Order ID: 50274

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Required Date:** 7/27/09

Comments:

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-35A Bolt		Purchased	No			260	Each	185.0000	20.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	185	
106993	12	
110467	173	

110467 SP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-13A Bolt		Purchased	No			260	Each	568.0000	80.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	568	
107321	1	
107534	5	
107959	23	
109285	37	
110552	66	
110865	3	
111477	9	
111925	424	
17406	0	

112314

9/8/27 10K SP

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 11:15:39 AM

Work Order ID: 50274

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Required Date:** 7/27/09

Comments:

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-36A x2		Purchased	No			260	Each	63.0000	20.0000			
Bolt												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	63	
109545	11	
110467	7	
110731	4	
111808	41	

112243 SA

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10 x4		Purchased	No			260	Each	1,211.000	40.0000			
Washer												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1211	
105442	95	
109059	2	
109840	23	
110985	202	
111279	13	
111668	876	

111668 9/18/27 10x SO

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 11:15:40 AM

Work Order ID: 50274

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Required Date:** 7/27/09

Comments:

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			260	Each	7,676.000	160.0000			
Washer												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	7676		
102929	2		
105906	4		
107321	23		
107939	114		
108161	553		
108827	31		
109249	69		
110523	340		
111279	1540		
111916	5000		111916
16941	0		

9/8/27 OK SC

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

July 14, 2009 11:15:40 AM

Work Order ID: 50274

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 7/27/09 **Required Date:** 7/27/09

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516		Purchased	No			260	Each	1,547.000	40.0000			
Washer												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	1547		
100564	2		
106167	6		
107534	34		
107959	43		
108246	46		
108672	2		
109059	49		
109752	22		
110363	46		
110523	57		
111279	240		
112082	1000		12082

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2230-3RevF		Manufactured	No			260	Each	219.0000	40.0000			
Lug												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	219		
22121	0		
47965	116		
48384	103		

50306 7/27

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Picklist Print

July 14, 2009 11:15:40 AM

Work Order ID: 50274

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Required Date:** 7/27/09

Start Qty: 10.00 **Required Qty:** 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2618RevB1	x2	Manufactured	No			260	Each	59.0000	20.0000			
Bushing												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	59	
45392	48	
45914	11	

50659 sd

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2856-400RevA	x2 @ 7.20" long	Manufactured	No			260	f	196.1300	6.0000			
Abraison Strip												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	196.13	
42437	47.93	
46543	148.2	

46543 sd

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3065-041RevB		Manufactured	No			160	Each	54.0000	10.0000			
Step Leg Assembly Hi												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST 350095	54	
47090	14	
48113	40	

09-08-24 8 2

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

July 14, 2009 11:15:40 AM

Work Order ID: 50274

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Required Date:** 7/27/09

Comments:

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3066-1RevB		Manufactured	No			160	Each	97.0000	20.0000			
Spacer												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST 351121	97	09-08-24 20
47185	11	
48414	86	

R

D3067-1RevA		Manufactured	No			110	Each	88.0000	10.0000			
End Plate												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST 351104	88	09-08-24 10
46334	-1	
48242	89	

f

D3067-1RevA		Manufactured	No			260	Each	88.0000	10.0000			
End Plate												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	88	
46334	-1	
48242	89	09-08-24 10

f

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Picklist Print

July 14, 2009 11:15:40 AM

Work Order ID: 50274

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Required Date:** 7/27/09

Comments:

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3219-1RevA Plate		Manufactured	No			160	Each	157.0000	20.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	157	
45397	19	
47296	138	

09.08.17 10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3235-1RevA +2 Mounting Lug		Manufactured	No			260	Each	291.0000	20.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	291	
45269	26	
45398	40	
46745	125	
47969	100	

45398 46745 4x 16x SH

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3272-1RevB Step		Manufactured	No			110	Each	0.0000	10.0000			

09.08.17 10

3 51190

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 11:15:40 AM

Work Order ID: 50274

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Required Date:** 7/27/09

Comments:

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3278-041RevC +1		Manufactured	No			260	Each	70.0000	10.0000			
Support Assembly												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	70	
47197	20	
47886	50	

MS20600-AD4W4		Purchased	No			180	Each	1,847.000	160.0000			
Rivets												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1847	
110731	215	
111359	46	
111477	586	
112082	1000	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 11:15:40 AM

Work Order ID: 50274

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Required Date:** 7/27/09

Comments:

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3 x2		Purchased	No			260	Each	1,777.000	20.0000			
Nut												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1777	
110844	34	
111274	743	
111668	1000	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4 x8		Purchased	No			260	Each	8,700.000	80.0000			
Nut												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	8748	
107499	5	
110507	2582	
111827	6000	
15924	0	
8182	161	
Main Warehouse		
t	-48	
110507	-48	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 11:15:40 AM

Work Order ID: 50274

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/27/09 **Required Date:** 7/27/09

Comments:

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L5 x2		Purchased	No			110	Each	763.0000	20.0000			
Nut												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	763		
110382	10		
111127	253		
111636	500	111636	9/8/27 (100)

S4

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS

A	04.03.01	NEW ISSUE
B	07.05.18	D3272-1 WAS D2622-120

RELEASED
07 06 04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		**D3272-041**	**STEP ASSEMBLY, HIGH LONG (LH)**
	X	**D3272-042**	**STEP ASSEMBLY, HIGH LONG (RH)**
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

△B

GENERAL NOTES:

1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

W/O 50274

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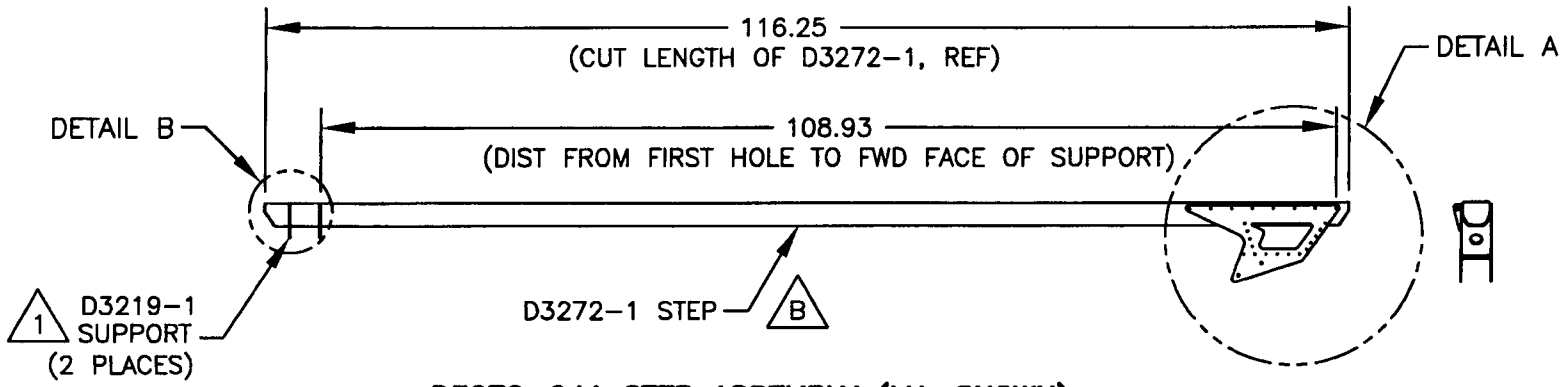
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

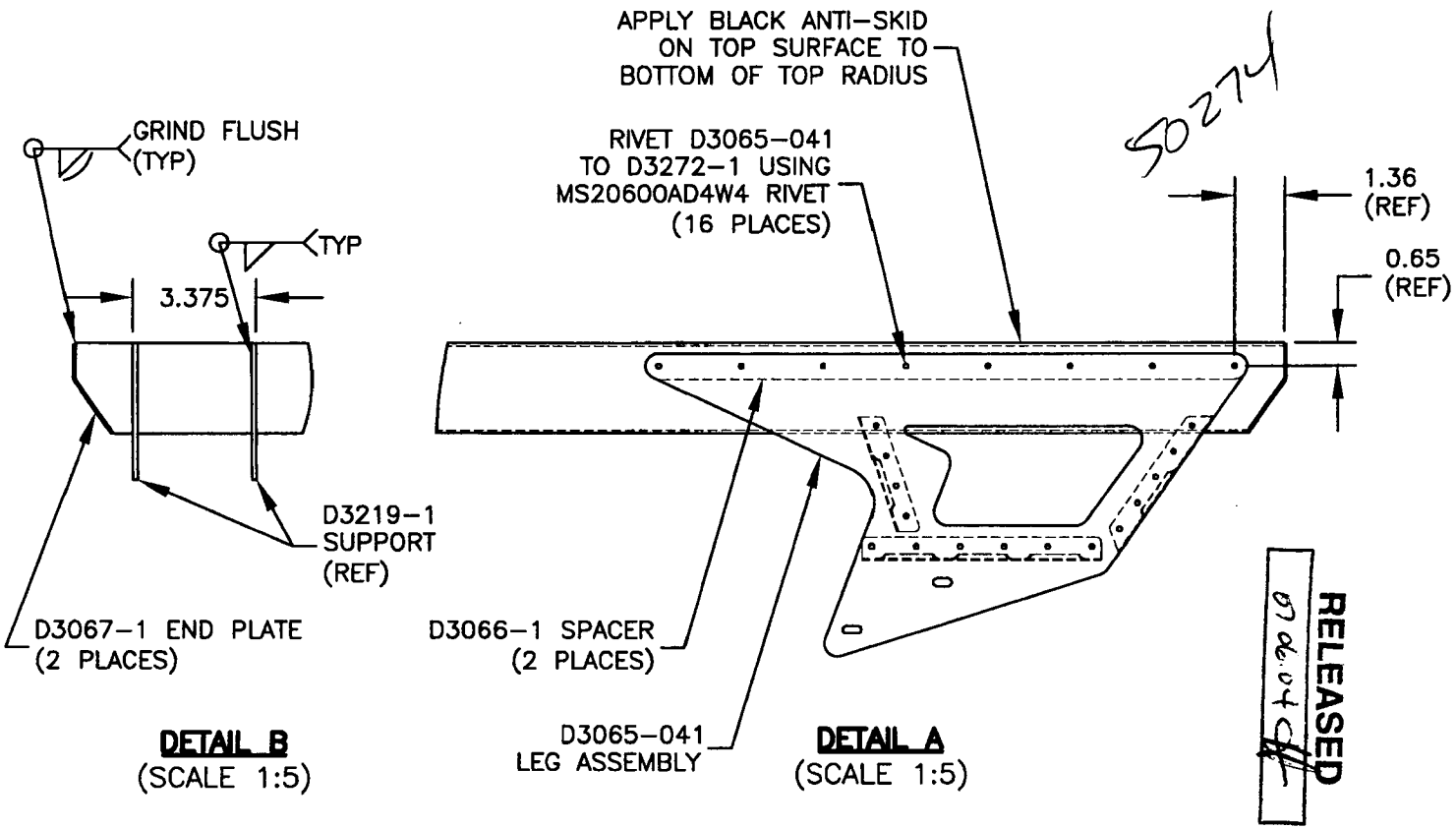
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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D3272-041 STEP ASSEMBLY (LH, SHOWN)

D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DETAIL B
(SCALE 1:5)

DETAIL A
(SCALE 1:5)

RELEASED
07.06.04

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3272 REV. B
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SHEET 2 OF 3 SCALE 1:20

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

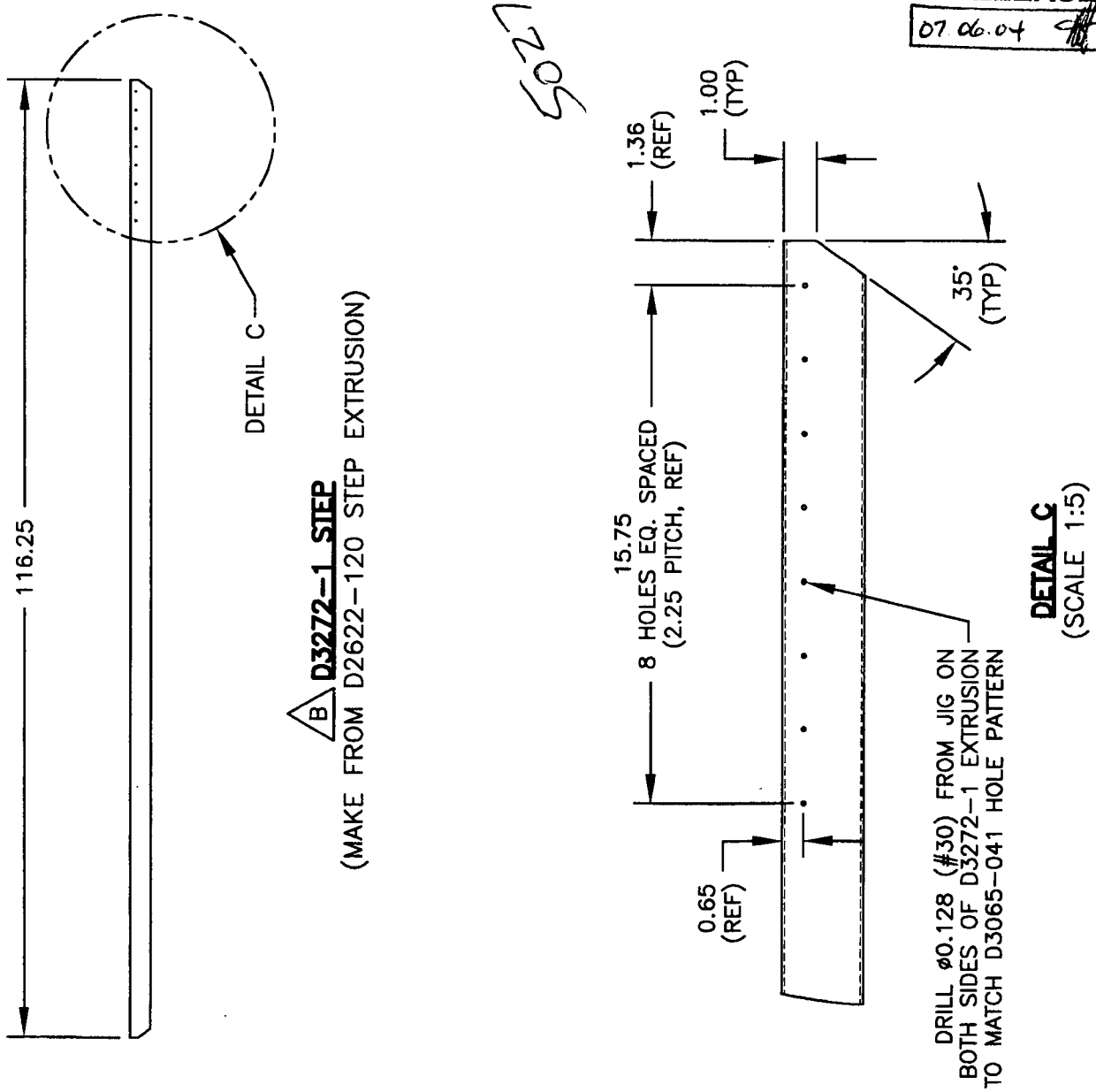
QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED
07.06.04



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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	***Heli-Access-Step***™, Long Step – High Skid, LH
	X							D350-591-212	***Heli-Access-Step***™, Long Step – High Skid, RH
		X						D350-591-213	***Heli-Access-Step***™, Short Step – High Skid, LH
			X					D350-591-214	***Heli-Access-Step***™, Short Step – High Skid, RH
				X				D350-591-215	***Heli-Access-Step***™, Short Step – Low Skid, LH
					X			D350-591-216	***Heli-Access-Step***™, Short Step – Low Skid, RH
						X		D350-591-311	***Heli-Access-Step***™, Long Step – High Skid, LH
							X	D350-591-312	***Heli-Access-Step***™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

HL205

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